

SPLIT-2

Work Order ID 64783 - 2

Friday, December 17, 2010 7:53:10 AM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

30

Start Date: 12/16/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: 10-12-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Cut to 1.450" Long

Jcaspa Bandsaw

cut extension @ meter

110

0.00



HAAS I

Memo

0.00

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV:

DWG REV:

HAAS CNC vertical machine #1

DEBURR

*Purchasing*

issue 710, 13326 to meter

machine as per dwg D3910 REV. B

CX 11/01/20 (18) 30

CX 11/01/27 (18)



# Work Order ID 64783

Friday, December 17, 2010 7:53:10 AM



Page 2

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 12/16/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC  
Quality Control

QC2-Inspect parts off machine FAI/FAIB

0.00

rec'd + inspect for transit damage

Memo

0.00

CL 11/6/127 (18)

11/4/17 (12)

130



QC  
Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

8/1/2/107

(x12)

140



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

12 11/6/10



# Work Order ID 64783

Friday, December 17, 2010 7:53:10 AM

Page 3

Item ID: D3910-3

Accept

Revision ID:

Item Name: Crosstube Lug

Start Date: 12/16/2010 Start Qty: 16.00

Required Date: 1/19/2011 Req'd Qty: 16.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115981

Memo

START: 5:30  
OPEN T: 3:30  
FINISH: 4:00

0.00

12

11-02-4

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

12

11-02-08

170



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

12/18/10

# Work Order ID 64783

Friday, December 17, 2010 7:53:10 AM



Page 4

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 12/16/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/08 *[Signature]*

*MF*

11-02-08

# Picklist Print

Friday, December 17, 2010 7:53:14 AM

Page 1

Work Order ID: 64783

Parent Item: D3910-3

Parent Item Name: Crosstube Lug



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD  
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423

Manufactured

No

100

f

550.0314

0.13

~~2189474~~

3.9



Lug Extrusion



CL 11/01/20

## Location

## Loc Qty

## Loc Code

MAT06

550.0314265

43722

180

45800

82.0314265

63005

288

~~214~~ 3.9

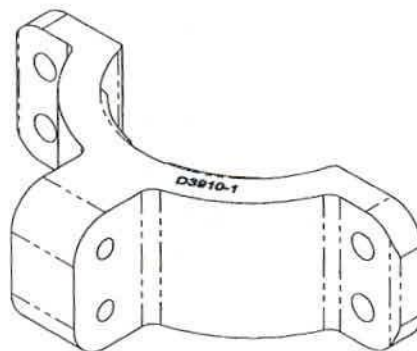
D3910-3P

X 26 30

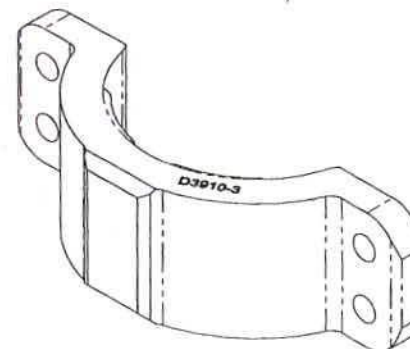
CL 11/01/27 x18



SIZE 1  
 PART NO.  
 ENCLOSURE  
 UNCONTROLLED  
 SUBJECT TO CHANGE  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 64783  
 10-12-17



**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**

**RELEASED**  
 2010-03-22  
 MP

**NOTES:**

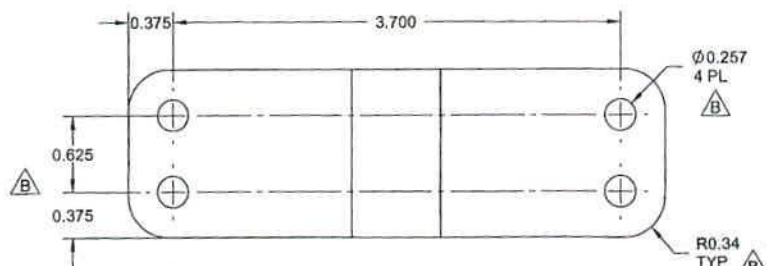
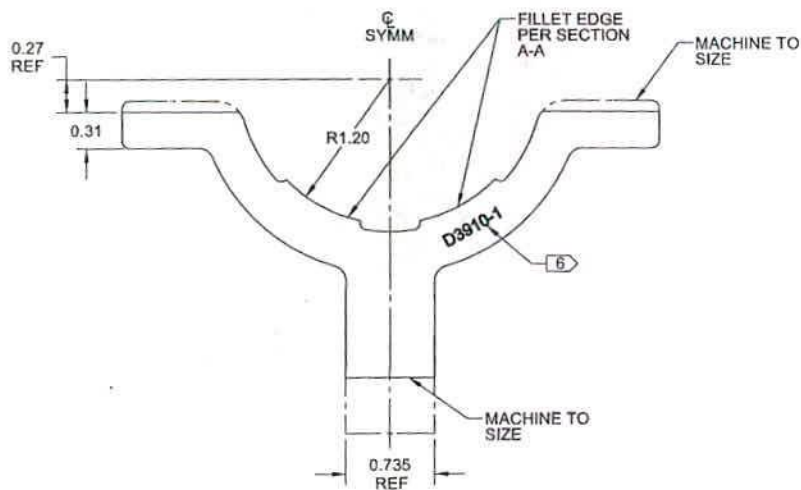
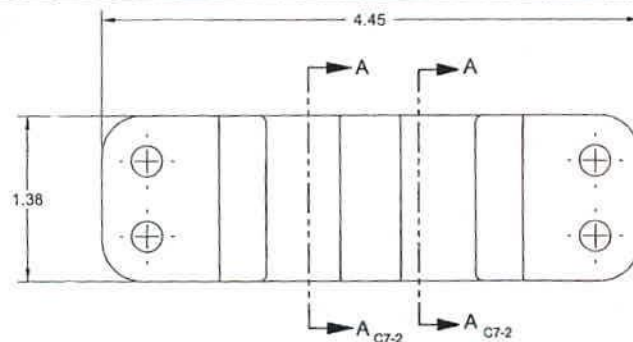
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs  
 -3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 Fillet WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR COPIES OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

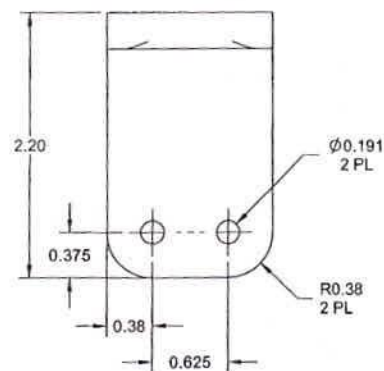


ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A**  
C4-2  
C5-2



**D3910-1 X-TUBE LUG**



**RELEASED**  
2010-03-22

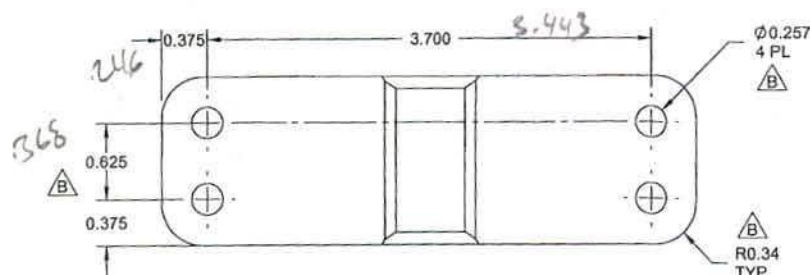
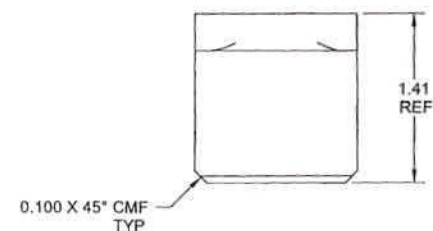
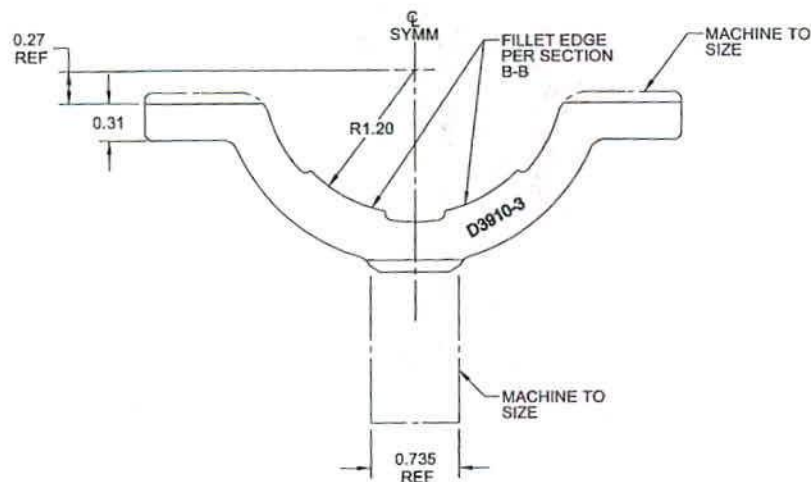
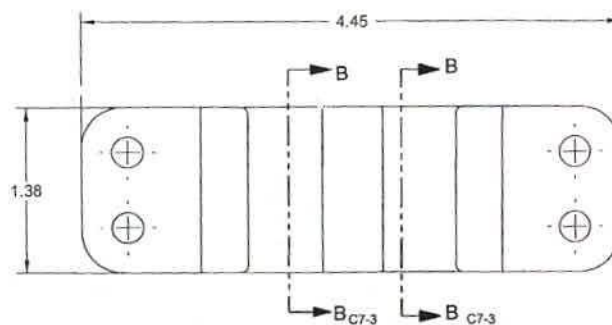
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3910</b>	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
DE APPR.		<b>X-TUBE LUG (350)</b>	SCALE
DATE	10.03.16		NTS
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ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL

**SECTION B-B**  
C4-3  
C5-3



**D3910-3 X-TUBE LUG**

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13326

Purchase Order Date 1/20/11  
PO Print Date 1/21/11

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

REVISED

Contact Name  
Vendor Phone 613 678 3957  
Vendor Fax 613 678 3956  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
C/L 1/10/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P C/L 1/10/11 rev 18	Crosstube Lug	1/28/11 Yes	30.00 Each	Yours ppd Mc 12	\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B64783				
2	D3910-1P	CROSSTUBE LUG	1/28/11 Yes	✓ 30.00 Each	Yours ppd	\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B65631				
3	D4091-1P	LUG	1/28/11 Yes	24.00 Each	Yours ppd	\$20.0000	\$480.00
		Special Inst:	MACHINE AS PER DWG D4091 REV. A B65626				
4	D3041-1P	Clamp	1/28/11 Yes	20.00 Each	Yours ppd	\$31.0000	\$620.00

1/21/11



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 17749

Date: Jan 31, 2011 Feb 4, 11

Page: 1

<b>Sold to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13326	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug	Each	30	12	
D3910-1 Crosstube Lug	Each	30	30	
D4091-1 Lug as per drawing D4091 Rev.A	Each	24		24
D3041-1 Clamp	Each	20		20
D3041-3 Clamp	Each	20		20
Received by _____		Thank you for your order!		



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
12	D3910-3	Crosstube Lug	13326
30	D3910-1	X-Tube Lug	13326

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

*Sulor/07*

Vankleek Hill, February 4, 2011